

Date: Tuesday, 10/06/2008 12:54:19 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH ASSEMBLY
Job Number	: 39783		
Estimate Number	: 10303		
P.O. Number	:	Part Number	: D2586
This Issue	: 10/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2586 REVD
First Issue	: / /	Project Number	: N/A
Previous Run	: 38174	Drawing Revision	: D
	Type : PURCHASED PARTS	Material	:
Written By	:	Due Date	: 19/06/2008
Checked & Approved By	: <u>Julie Lecocq</u>	Qty:	100
Comment	: Est E 02.01.31 Added Inspect level 21 NG	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6535C208100110

Possible Supplier: Southco, P/N: C2-32-25

Certification Required

(100)

2.0	C23225	DOOR LATCH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

DOOR LATCH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

1-Receive and inspect for transit damage

2-Attach certification

3-Stock Keys as: C2-32-25 Keys

4-Discard hardware

10/6/18

(100)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

counted
808/66/19 (402)

5.0	D30157	Lock Nut
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Lock Nut

Pick:

Qty

Part Number

Description

Batch

1

D3015-7

Lock Nut

B39811
808/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:19 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 39783

Part Number: D2586

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Hole to 0.191"

2-Counterface as per Dwg D2586

3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

08/06/24 (102)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/24 (102) counter

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 225 (overstocked)

AS 08/06/25

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



MF 08-06-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

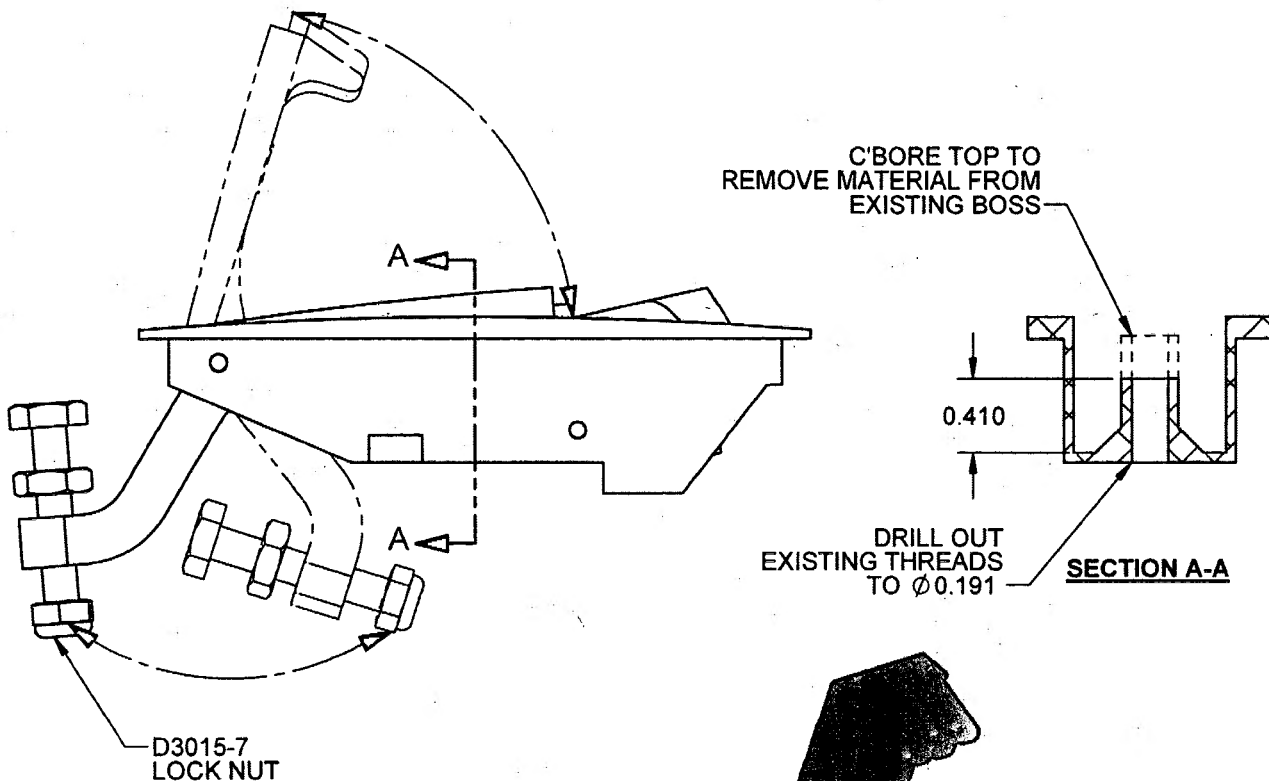
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2586	REV. D SHEET 1 OF 1
DATE 06.10.19	TITLE DOOR LATCH		SCALE 1:1
REV	DATE	DESCRIPTION	
A	96.07.15	NEW ISSUE	
B	97.07.23	CHANGED C'BORE DEPTH	
C	97.09.03	REVISED C'BORE DEPTH	
D	06.10.19	ADD D3015-7 P/N: UPDATE DRAWING	

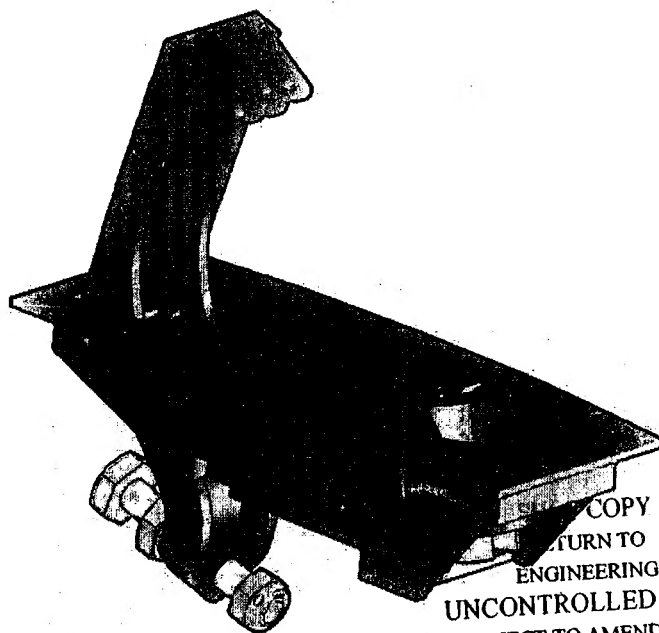
RELEASED
06.12.22



D2586 DOOR LATCH

NOTES:

- 1) MAKE FROM SOUTHCO P/N: C2-32-25
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **39183**

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Dallas, TX 75220

1-800-465-6281
www.tchweb.com



CERTIFICATE OF COMPLIANCE

Date: 06/17/08

Customer Name: *Dart Aerospace Ltd*

Customer P.O. No.: 6535

TCH Order No.: 81993

Invoice No.: 99686

Date shipped: 06/17/08

TCH Part No.: 555-C23225

Item Description: *BLK LEV LATCH RAISED*

This is to certify that the items identified herein have been produced in accordance with applicable instructions and or specifications, drawings, approved samples and/or other descriptions set forth in the Purchase Order.

Signature: _____

Title: _____

[Signature]

Supervisor



T.C.H. Sales Inc.
40 Emblem Court,
Toronto, Ont. Canada,
M1S 1B1

T.C.H. Sales Inc. confirms that substances regulated by the EU Directive 2002/95/EC "on the restriction of the use of certain hazardous substances in electrical and electronic equipment" are not intentionally used in parts listed below.

These hazardous substances include:

- Lead
- Cadmium
- Chromium (Vi)
- Mercury
- Polybrominated Biphenyls
- Polybrominated Diphenylethers

Specifically, Part Numbers:

These part numbers do not contain any of the above-mentioned hazardous substances.

Customer P.O. # 6535

TCH Order # 81993

Date Shipped 06/12/08

Signature: 

Title: Supervisor

T.C.H. Sales Inc. 40 Emblem Court, Toronto, Ont. Canada, M1S 1B1 tel (800) 465-6281, fax (416) 299-3255

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Trans Continental Hardware Inc. 4325 Warren Ravenna Road, Newton Falls, Ohio, 44444 tel (877) 348-7486, fax (330) 872-3360 (Foam Division)